

Work Order ID 66153-1

Monday, February 07, 2011 11:18:00 AM

SPLIT



Page 1

Item ID: D3564-9

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 2/8/2011

Start Qty: 20.00 12



Cust Item ID:

Required Date: 2/22/2011

Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan: MUF

Date: 1-02-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev: D Prog

Rev: D 2-Deburr if necessary

B 11-2-8

(20)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 11-2-8

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

MUF 11 02 08 (20)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Monday, February 07, 2011 11:18:00 AM



Stop



Required Date: 2/22/2011 Req'd Qty: 20.00

Customer:

Run Start

Date: _____

Tooling:

Date:

Stop

Date:

SPC (Y/N):

Date:

Insp.
Stamp

0.00



NC BRAKE

Memo

0.00

Brake NC

Deburr if necessary. Form on Brake as per Dwg D3564 using Jigs DT 8129 and DT 8155. Form Joggle as per Dwg D3564 on brake using Jig DT 8157.

SB 11/02/00

22

0.00



QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

Ensure joggle as per dwg D3429

11 02 08 (20)

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Qty	Description	Batch	A/R	2059B Hardcoat
116787	Weld hardcoat as per Dwg D3564			

EL 11-2-22 (X12)

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Work Order ID 66153

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Page 3

Item ID: D3564-9

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 2/8/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Sublot 22

Memo

0.00

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Sublot 22

Memo

0.00

(H2)

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M 115128

Memo

0.00

START TIME:

10:35

OVEN TEMPERATURE:

320° FINISH TIME:

12:05

12 BL 11-2-23

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Work Order ID 66153

Monday, February 07, 2011 11:18:00 AM

Page 4

Item ID: D3564-9

Accept

Revision ID:

Item Name: Wearshoe

Start Date: 2/8/2011 Start Qty: 20.00

Required Date: 2/22/2011 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 0 21 11/02/23

200

Identify as per dwg & Stock Location: FP-19 0.00

Packaging

Memo

0.00

Packaging

12 BR 11-2-23

210

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/02/24

11-02-23

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, February 07, 2011 11:17:57 AM

Page 1

Work Order ID: 66153

Parent Item: D3564-9

Parent Item Name: Wearshoe



Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	222.2800	1.41	29.68421			



304/316 Sheet .063



B 11-2-8

Location

Loc Qty

Loc Code

MAT

222.28

111323

0

116623

222.28

116623



W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 66153
Description: Wearshoe		Part Number: D3564-9
Inspection Dwg: D3564	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.224	✓		V HB02	
2.432	+/-0.010	2.439	✗		V	
2.50	+/-0.030	2.500	✓		V	
6.000	+/-0.010	6.000	✗		T HB01	
12.104	+/-0.010	12.104	✓		T	
18.000	+/-0.010	18.00	✗		T	
18.000	+/-0.010	18.00	✓		T	
18.00	+/-0.030	18.00	✓		T	
9.00	+/-0.030	9.00	✓		T	
11.50	+/-0.030	11.50	✓		T	
0.300 x 0.300	+/-0.010	.301 x .303	✗		V	
Ø0.188	+0.005/-0.001	.189	✗		V	
R0.375	+/-0.010	.375	✗		R.G.	
0.063	+/-0.010	.059	✗		V	

Measured by: AB	Audited by: MML	Prototype Approval:	N/A
Date: 11-2-8	Date: 11-02-08	Date:	N/A

Rev	Date	Change	Revised by:	Approved
A	08.01.16	New Issue	KJ/EC/DD	

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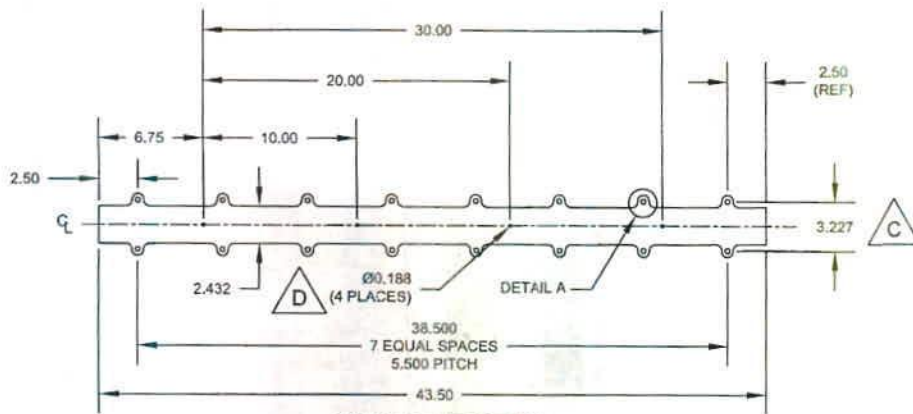
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

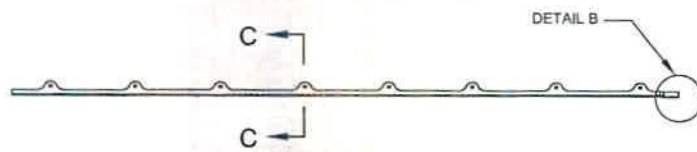
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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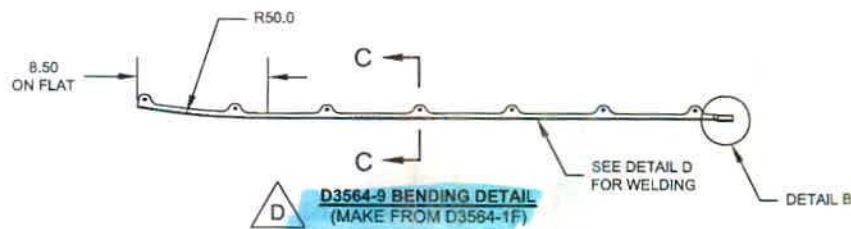
NOTE: Date & initial all entries



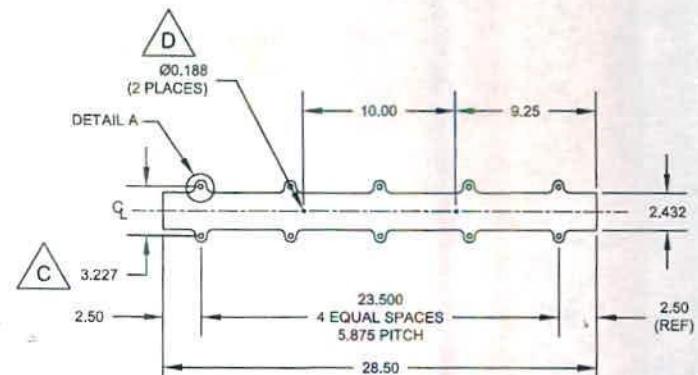
D3564-5F FLAT PATTERN



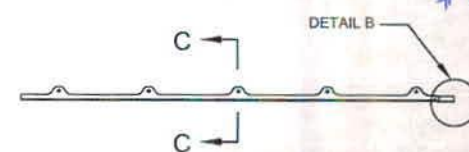
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



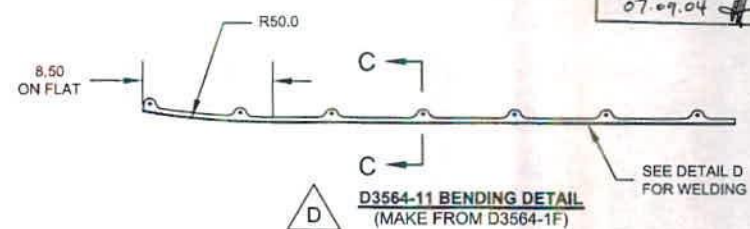
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

07.09.04

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CS		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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#66153

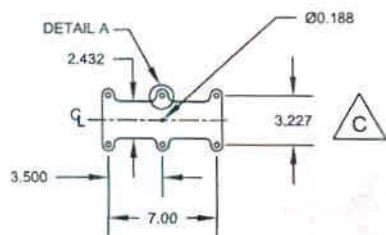
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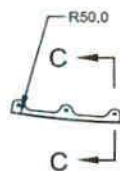
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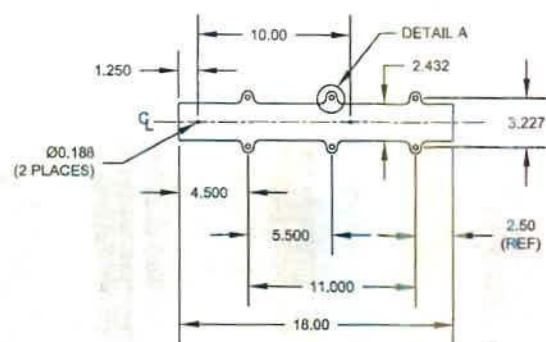
NOTE: Date & initial all entries



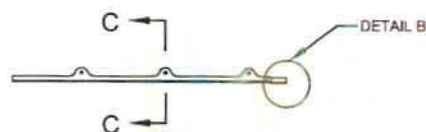
D3564-13F FLAT PATTERN



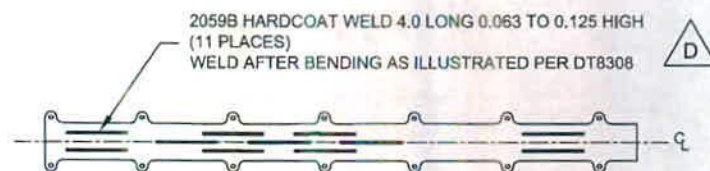
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



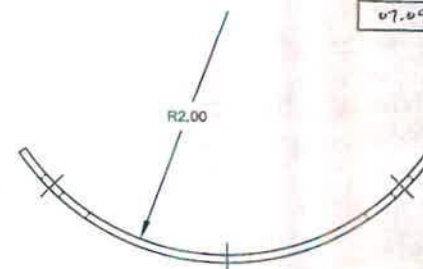
D3564-15F FLAT PATTERN



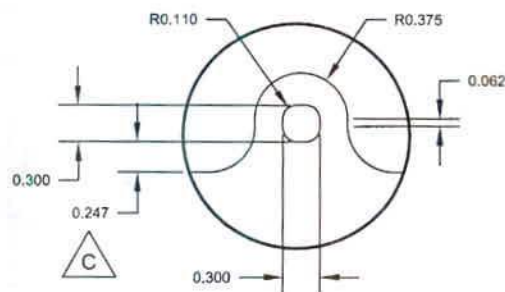
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



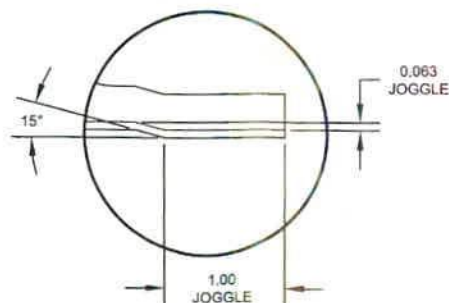
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

#66153

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